

Work Order ID 72996

Tuesday, August 23, 2011 10:07:44 AM

DWG
U/R

Page 1

Item ID: D350-748-101

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Installation, High Fwd

Start Date: 8/23/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/31/2011 Req'd Qty: 1.00

Customer:

Reference:

Run Start

Approvals: Process Plan: *11*Date: *11-08-23* Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D350-748-141

F

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PP D350-748-101

CHG002

110

0.00



BENDING MACHINE - CROSSTUBES

CNC Bend I

Memo

0.00

CNC Delta 100 Bender

Bend tube as per Dwg D350-748-141 using CNC bender program D350F and Folio FT

120

0.00



QC15- Crosstube Dimensional Check

QC

Memo

0.00

Quality Control

SCRAP*SWP**RD 11-9-28*

W/O: 72996		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-748-101 PAR #: N/A Fault Category: V-Tube NCR: Yes ☒ No ☐ DQA: 11 Date: 11.10.07
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: OK Date: 11/10/11

NCR:		WORK ORDER NON-CONFORMANCE (NCR) # 305604						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11.09.28	110	Twist > 0.8" RC: Process	W 11/10/03	SCRAP TUBE P 11.09.28	TW 11-10-3	11-10-3	W 11/10/03	S 11/07/30

NOTE: Date & initial all entries

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
125	HandFXtube	0.00							
	Hand Finishing Crosstubes								
	Memo ***Stress relief*** Heat treat crosstube as per QSI010 4.3 Temp: <u>375</u> Start time: <u>7h00</u> Finish time: <u>11h00</u>	0.00							
127	QC6- Inspect dimensions to drawing	0.00							
	QC								
	Quality Control								

① SAD 11-08-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Crosstubes	0.00							
Crosstubes	Memo	0.00							
Crosstubes	1-Drill Tube as per Dwg D350-748-141 Using DT8876 A,B &C Drill Jigs, Set-up drill table as per QS1 010								
	2-Deburr								
	3-Engrave Part # and Batch # as per Dwg D350-748-141								
	4-Remove all marks from tube within limits of D350-748-141								
	5- Apply a light coat of LPS3 on the interior of tube Batch: _____								
140 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control	CHECK 10 DEG HOLES WITH DT8876E (EUROCOPTER CLAMP)								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Outsource process-Cadplate per QSI017 4.1.9.1	0.00							
	Outsource3	0.00							
	Memo								
	Issue P/O: _____								
	Stress relief at 375° for 5 hours								
	Magnetic Particle Inspect per ASTM E1444								
	Cadium Plate per AMS-QQ-P-416B, Class 1, Type 2								
	Embrittle relief at 375° for 8 hours, Chromate Treat								
	Possibe Supplier: Southwest United Industries								
	Ensure Certificate of Conformity is attached								
160	Receive & Inspect for Damage & Mat'l Certs	0.00							
	Packaging	0.00							
	Memo								
	Ensure certificate of conformity is attached								
170	QC5- Inspect part completeness to step on W/O	0.00							
	QC	0.00							
	Memo								
	Quality Control								

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

0.00



SprayPaint

SprayPaint

Memo

0.00

Spray Painting

1-Prime inside crosstube as per QSI 005 4.2

2-Prime Outside of Tube as per Dart QSI 005 4.2

190

0.00



QC

QC14- Inspect Spray Paint

Memo

0.00

Quality Control

Then, Wrap in plastic bag to protect from scratches

200

0.00



Crosstubes

Crosstubes

Memo

0.00

Crosstubes

1-Install Ground wire Insert, then insert screw and washer

2-Install Abrasion strips as per Dwg D350-748-141 & QSI 035.

3-Install supports Using Dt8876 as per Dwg D350-748-141, Torque to 60-80 IN-LBS

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Cust Item ID:

Required Date: 8/31/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240



Packaging

0.00

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-748-101

Location: _____

PPP Rev: _____

250



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

WLL-1005

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

Tuesday, August 23, 2011 10:07:48 AM

Page 1

Work Order ID: 72996

Parent Item: D350-748-101

Parent Item Name: Crosstube Installation, High Fwd



Start Date: 8/23/2011

Required Date: 8/31/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 06-07-05 JLM
 IPP Rev:B Update qty of MS21042L5 06-09-12 KJ
 IPP Rev:C Rev B 07-11-15 DD
 IPP Rev D Combined manufacturing 08.04.02 EC verified by: DD
 IPP Rev:E 08-06-24 revD as per dwg DD verified by:EC IPP Rev:F
 10.08.04 added QSI010 4.3 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D350-748-141TRN 		Manufactured	No			110	Each	0.0000	1	1			
Crosstube Turning Detail													
ALS4-1032-225 		Purchased	No			200	Each	931.0000	1	1			
Insert													

B70650

SAP 11-09-27

Location	Loc Qty	Loc Code
ST282	931	
110768	62	
117717	9	
118386	860	

AN960JD10 	NAS1149D0363J	Purchased	No			200	Each	0.0000	1	1			
Washer													
D2856-400 		Manufactured	No			200	f	266.7845	1.181	1.243158			
Abraison Strip													

Location	Loc Qty	Loc Code
ST403	50.1149	
68076	50.1149	
ST409	216.6696	
63735	0.6696	
71164	216	

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 2

Work Order ID: 72996



Parent Item: D350-748-101



Parent Item Name: Crosstube Installation, High Fwd

Start Date: 8/23/2011

Required Date: 8/31/2011

Start Qty: 1.00

Required Qty: 1.00

D3502-1 Manufactured No

200 Each

25.0000

2 2



Support

Location

Loc Qty

Loc Code

ST063

25

61206

12

61843

3

64004

10

MS21920-20

Purchased

No

200 Each

102.0000

2 2



Clamp (per MIL-DTL-8783C)

Location

Loc Qty

Loc Code

LG050

102

116799

10

118236

42

118649

50

MS27039-1-10

Purchased

No

200 Each

299.0000

1 1



Screw

Location

Loc Qty

Loc Code

ST290

99

117441

99

ST291

200

118612

200

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 72996

Parent Item: D350-748-101

Parent Item Name: Crosstube Installation, High Fwd



Start Date: 8/23/2011

Required Date: 8/31/2011

Start Qty: 1.00

Required Qty: 1.00

AN4-41A Purchased

No

220

Each

299.0000

8

8



Bolt



Location

Loc Qty

Loc Code

ST360

299

115108

74

115705

50

116191

50

117619

50

117795

25

118451

50

AN4-6A Purchased

No

220

Each

1,184.000

16

16



Bolt



Location

Loc Qty

Loc Code

ST356

984

116924

84

117872

200

118422

300

118628

400

ST358

200

117514

200

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
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Parent Item: D350-748-101



Parent Item Name: Crosstube Installation, High Fwd

Start Date: 8/23/2011

Required Date: 8/31/2011

Start Qty: 1.00

Required Qty: 1.00

D3501-1

Manufactured No

220 Each

321.0000 16 16



Bushing

LocationLoc QtyLoc Code

ST063

221

61984

19

68939

102

70682

100

ST066

100

67757

100

MS21042L4

Purchased No

220 Each

4,639.000 24 24



Nut

LocationLoc QtyLoc Code

ST300

4639

117441

494

117601

645

117885

1500

118451

2000

MS21042L5

Purchased No

220 Each

1,185.000 4 4



Nut

LocationLoc QtyLoc Code

ST300

1185

116105

5

116548

53

117441

498

117591

43

117611

90

118179

496

Tuesday, August 23, 2011 10:07:49 AM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

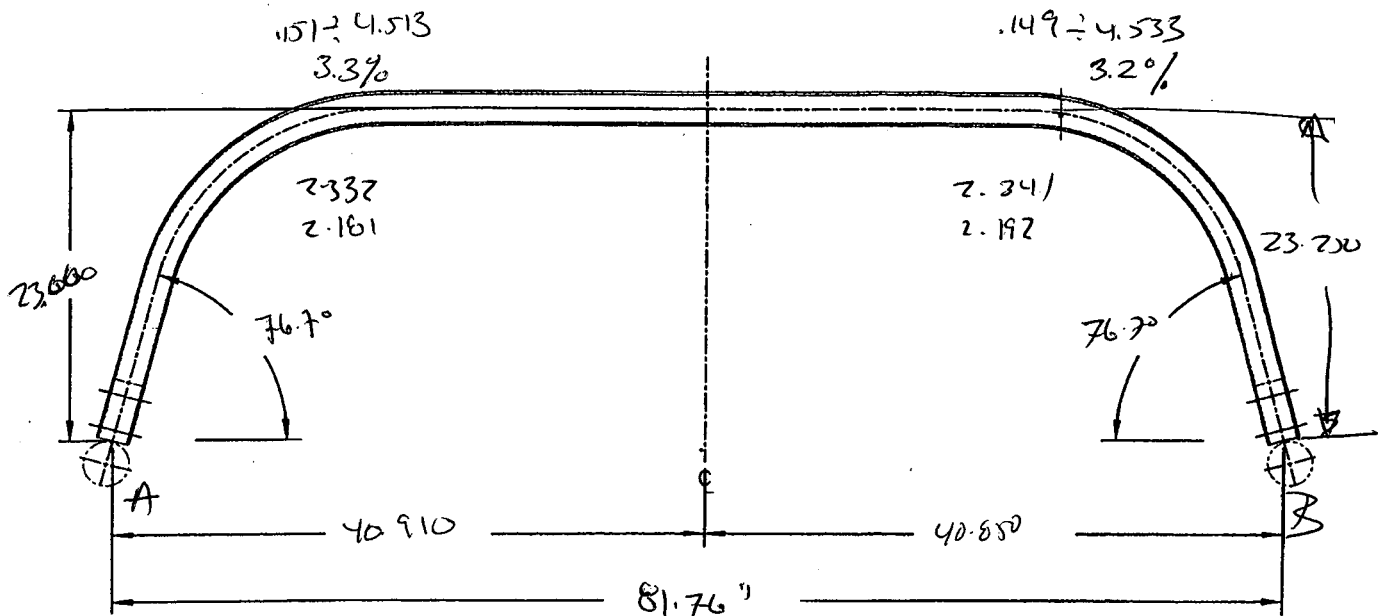
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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DART AEROSPACE LTD		Work Order:	12994
Description: Crosstube High Fwd (AS350/355)		Part Number:	D350-748-101
Inspection Dwg: D350-748-141 Rev: E		Page 1 of 1	

Required Dimension	Min	Max
Height	23.13	23.37
1/2 Span	40.78	41.02
Angle	75	77
Total Span	81.56	82.04



Comments
twist $20.862"$
SIDE A = 3.3% crushin' @ 42 PASS
SIDE B = 3.2% crushin' @ 38 PASS
Bottom line, acceptable CP H.O.T. 20 @ 0.12

QC15 Inspection	
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	10.08.23	Dwg Rev updated	KJ	

[Signature] 100523

Item	Qty -141	Part Number	Description
1	X	D350-748-141	CROSSTUBE ASSEMBLY (AS 350/355 HI FWD)
2	1	D6015-125	CROSSTUBE (OR D6017-115)
3	2	D3502-1	SUPPORT
4	2	D2856-400-710	ABRASION STRIP
5	1	AELS-1032-225	INSERT
6	1	NAS1149D0363J	WASHER (OR AN960JD10)
7	2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
8	1	MS27039-1-10	SCREW

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6015-125 OR D6017-115
FINISHED LENGTH = 110.270±0.06
- 2) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2
CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: DART PART NUMBER "D350-748-141" AND BATCH NUMBER ON INSIDE OF CUFF
PER DART QSI 044 6.4 (VIBRATING STYLUS)
- 7) WEIGHT: 30.45 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE, EXCEPT FOR Ø0.297 HOLE.
- 9) BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO
BENDING IS 6% BASED ON O.D.
- 11) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING. ACCEPTABLE TO
VERIFY TENSILE STRENGTH BY HARDNESS TEST PER ASTM E18 TO 40-45 HRC.
- 12) INSTALL D2856-400-710 ABRASION STRIPS WITH A GAP ON BOTTOM SIDE OF CROSSTUBE,
CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- 13) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES,
NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY.
CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE
MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO
CRACKING/CHIPPING/GROOVES.
- 14) TORQUE CLAMPS 60 TO 80 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT
NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.
- 15) MAX TWIST AFTER BENDING: WITH XTUBE LAYED FLAT ON SURFACE, THE DIFFERENCE BETWEEN
CUFF HEIGHTS FROM THE SURFACE MAY BE NO LARGER THAN 0.25 (ZN C1-3).

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 12774

UNDER REVIEW

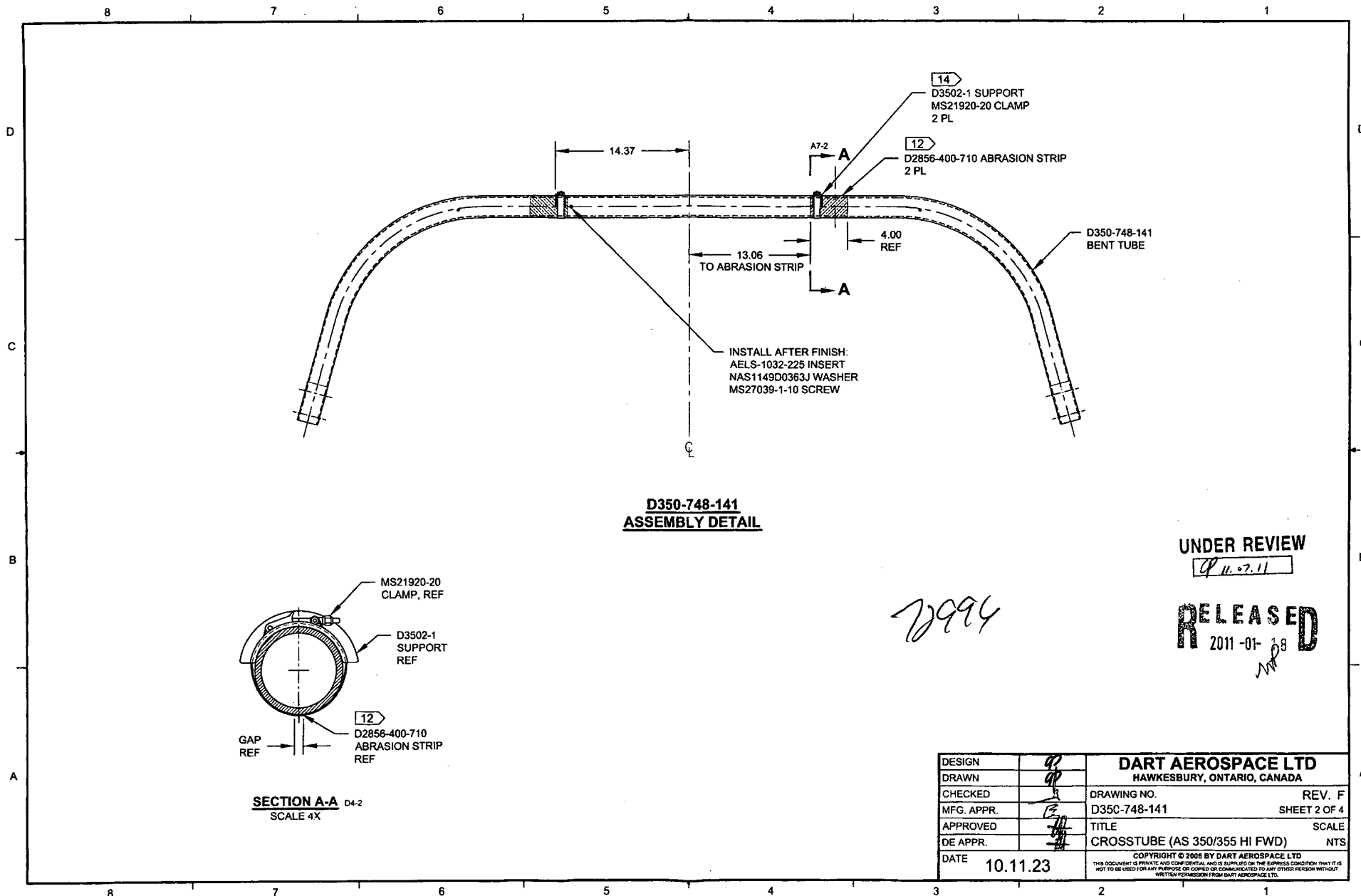
RELEASED
2011-01-18

F	ADD HRC TEST OPTION (B8-1) PER PAR 09-040, ADD TWIST LIMIT (A8-1, C1-3), ADD D6015-125 OPTION (C8-1), STOCK DIM NOW MACHINED (D1-4)	CP	10.11.23
E	REVISE GENERAL NOTES; UPDATE TO CURRENT ADD STANDARDS; RELOCATED FLAG #6 PER PAR 08-046 (ZN A6-3); TOLERANCES (ZN C6-3, D1-3)	RF	09.09.30
D	MAG. PARTICLE AND CAD PLATE AS MFD.	CP	06.10.31
C	ADD CAD PLATING	CP	06.08.14
B	ADD D6017-115 & PRIME AND PAINT	CP	06.06.30
A	NEW ISSUE	CP	06.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.11.23		

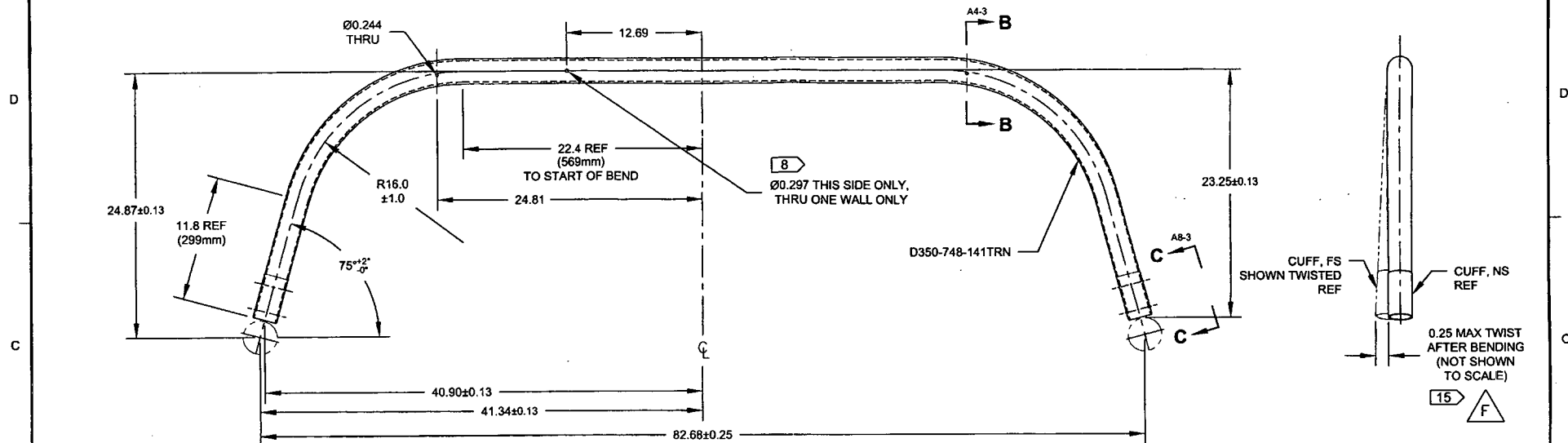
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. F
D350-748-141 SHEET 1 OF 4
TITLE SCALE
CROSSTUBE (AS 350/355 HI FWD) NTS

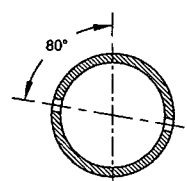
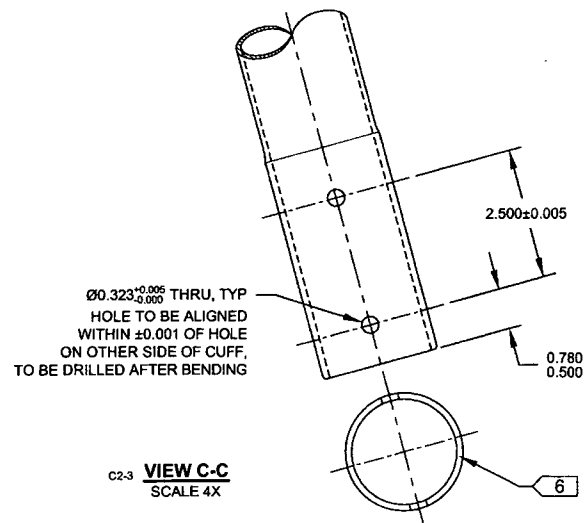
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8 7 6 5 4 3 2 1



D350-748-141
BENDING AND DRILLING DETAIL 10



UNDER REVIEW
11.27.12

RELEASED
2011-01-18
MD

DESIGN	DP	DART AEROSPACE LTD	
DRAWN	DP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	B	DRAWING NO.	REV. F
MFG. APPR.	DP	D350-748-141	SHEET 3 OF 4
APPROVED	DP	TITLE	SCALE
DE APPR.	DP	CROSSTUBE (AS 350/355 HI FWD)	NTS
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